

Work Order ID 86561

July-05-12 10:34:24 AM

Blue

86561

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Item ID: D2651-1

Revision ID:

Item Name: Plug

Start Date: 7/05/12

Start Qty: 80.00

80

Required Date: 7/20/12

Req'd Qty: 80.00

80

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D26512- Deburr

12/07/26

120



110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12/07/26

120



120

QC8- Inspect parts - second check

0.00

120

QC

Memo

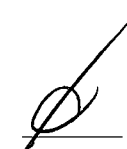
0.00

Quality Control

DAS
13
9-89

12/7/26

120



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Item ID: D2651-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plug
 Start Date: 7/05/12 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				120	76	12-7-30	
155 *155* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME B 117319 DELFLEET BLUE B 121149 CLEAR DELFLEET B 118342	0.00 0.00				120	12-8-9	120	
165 *165* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				120			

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Item ID: D2651-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plug
 Start Date: 7/05/12 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>IFA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

SD SL 12/08/13

MLJ 12/08/14

12-08-14

Picklist Print

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Page 1

Work Order ID: 86561

Parent Item: D2651-1

Start Date: 7/05/12

Required Date: 7/20/12

Parent Item Name: Plug

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: A02.04.15New Issue NG
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	103.6680	0.0401	3.3768421	6.000	12/07/26	

Location	Loc Qty	Loc Code
MAT012	103.668	
114488	1.997	
117379	9.288	
119043	92.383	

6.000'

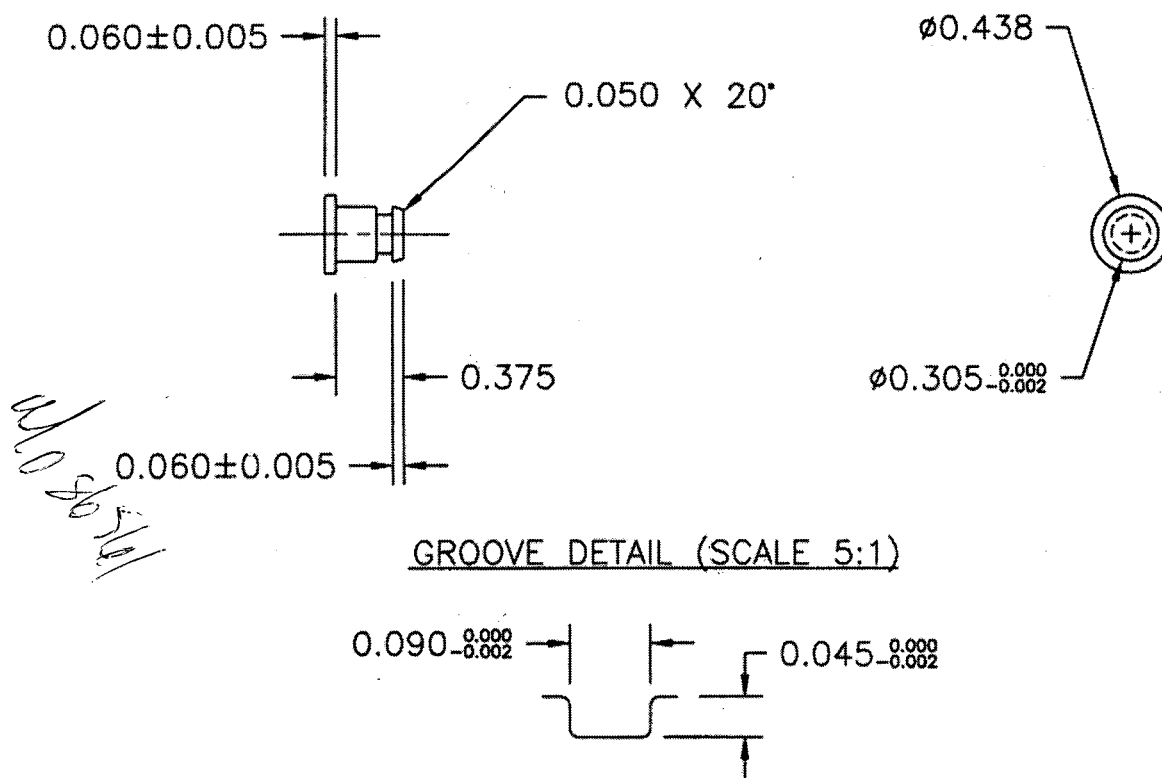


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19	TITLE PLUG		SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

03.12.19

D2651-1 PLUG:



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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